

Date: Wednesday, 04/02/2009 11:01:21 AM
User: Linda Lacelle

BLUE

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PLUG
Job Number :	45490		
Estimate Number :	10512		
P.O. Number :		Part Number :	D26511
This Issue :	04/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2651 REV. B -BLUE
First Issue :	/ /	Project Number :	N/A
Previous Run :	44342	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	11/02/2009
Written By :		Qty:	60
Checked & Approved By :		Um:	Each
Comment :	Est: A 02.04.15 New Issue NG Est: B 05.12.12 added deburr EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0421 f(s)/Unit Total : 2.5263 f(s)
Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
(M6061T6R0500)
Batch: M10532

09/02/07

61 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HAAS CNC VERTICAL MACHINING #1
1- Turn as per Folio FA219 and Dwg D2651

2- Deburr

09/02/07

61 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/02/07

61 pcs

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F.

09/02/08

61 pcs

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr ias per dwg D2651

M. 09/02/09

09/02/09

61x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SS

09-02-10

(61)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: spray painting

PRIME GREY

PAINT DELFLEET BLUE

CLEAR DELFLEET

(61)

ET 09-02-23

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT

ml 09 02 24

(61)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-A

SS

09-02-24

(61)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/24

Job Completion



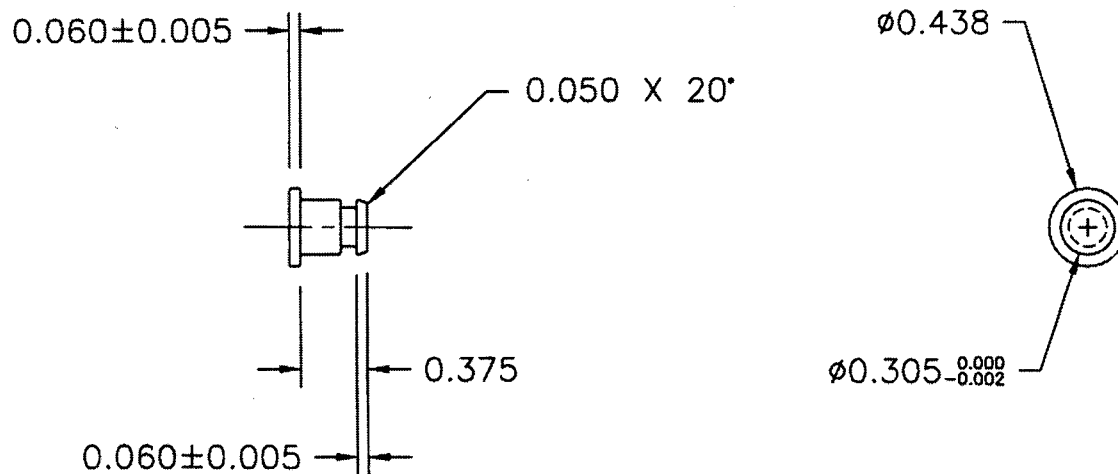
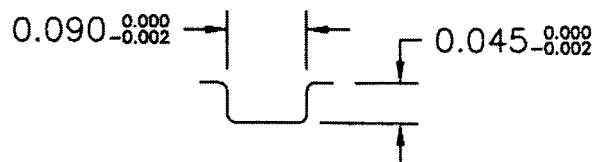
MF 09-02-24

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED

03.12.19

D2651-1 PLUG:GROOVE DETAIL (SCALE 5:1)

45490

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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